

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005726**Date Inspected:** 05-Mar-2009**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 830**OSM Departure Time:** 1630**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking, and Deviation Saddles**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Art Peterson was present during the times noted above for observations relative to the work being performed in Fabrication shop #4.

Grinding and Welding Operation: West Deviation Saddle Segment W2W1

The QA Inspector observed the following work in process: grinding operation of the cope holes on the Rib plate to Stem plate at locations 4-12 and 4-16. The QA Inspector also observed the fillet welding operation around the cope holes on the Rib plate to Stem plate at locations 4-8 and 4-10. The QA Inspector observed QC Inspector Mr. Chung Fu Kuan verify prior to the start of welding that the preheat temperature of 160 degrees Celsius was maintained and the welding parameters of JSW welding personnel Mr. M. Kashiwada (08-2008) and Mr. M. Kubota (74-3666) were in compliance with WPS SJ-3011-14 per the FCAW process in the (2F) horizontal position.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 510 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Peterson, Art	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz, Joe	QA Reviewer

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